



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3488-041
Job Sheet 173381



Part No: **D3488-041**

Job Qty: 6 ea

Part Name: Blade Fitting LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/1/18

Job Tracking No:

Due Date: 3/12/18

Created By: Logan David

Type: Stock

Description:

Note: DWG DSK101 REV D, D3488 REV B IPP Rev:A New Issue 06-02-28 JLM IPP Rev:B As per Rev B 06-03-30
JLM IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		3/9/18	0.00	0.00	Start Up Machining-2		M.P. 18/05/12
100	Doosan	6 pcs		3/10/18	0.00	5.13	Doosan		M.P. 18/05/12
110	QC	6 pcs		3/10/18	0.00	0.00	QC2 Machining-2		M.P. 18/05/12
120	CNC Vertical Machining	6 pcs		3/10/18	0.34	4.96	HAAS1-3		M.P. 18/05/12
130	QC	6 pcs		3/10/18	0.00	0.00	QC2 Machining-2		M.P. 18/05/12
140	QC	6 pcs		3/10/18	0.00	0.00	QC8 Machining-2		M.P. 18/05/12
150	HandFinish	6 pcs		3/10/18	0.00	0.19	HandFinish1		M.P. 18-05-22
160	Powdercoat	6 pcs		3/12/18	0.00	0.21	Powdercoat1		M.P. 18-05-22
170	QC	6 pcs		3/12/18	0.00	0.00	QC3		M.P. 18-05-23
180	HandFinish	6 pcs		3/12/18	0.00	0.00	HandFinish4		M.P. 18-05-23
190	QC	6 pcs		3/12/18	0.00	0.00	QC5		M.P. 18-05-23
200	Packaging	6 pcs		3/12/18	0.00	0.00	Packaging3-1 FP001		M.P. 18-05-23
210	QC21-SA	6 Ea		3/12/18	0.00	0.00	QC21		M.P. 18-05-23

Part Op 100 - 1-Turn as per Dwg DSK 101 & Folio FA625
Descriptions: 120 - 1-Machine as per Folio FA625 & Dwg D3488
160 - START TIME: 2:55 O.V.T. 3:00 FINISH 3:00. M138839
180 - Install Inserts as per Dwg D3488
200 - LOCATION : FP001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6103-003	Round Billet, Aluminum	6 Ea (1 ea)	90-Start up Operation	
ALS7-1032-225	Insert	24 Ea (4 ea)	180-HandFinish	5058138

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6103-003	6	9	0
180-HandFinish	ALS7-1032-225	24	1,078	0

Part Specifications

Specifications could not be found.

Plex 3/1/18 11:02 AM dart.logan.david

DART AEROSPACE LTD	Work Order: 173381
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2	Part Number: D3488-1
Inspection Dwg: D3488 / DSK101 Rev: B / D	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	+/-0.005	2,150	✓		MJP-04	vern
Ø2.780	+/-0.005	2,776	✓			
Ø3.125	+/-0.010	3,120	✓			
Ø3.346	+/-0.010	3,345	✓			
0.125 x 45°	+/-0.010 x +/-0.1°	0,125 x 45°	✓			
8.000	+0.030/-0.000	8,015	✓			
9.250	+/-0.010	9,251	✓			
0.188	+/-0.010	0,187	✓			
R0.032	+/-0.010	0,032	✓			
R0.062	+/-0.010	0,062	✓			
Ø0.297	+0.005/-0.001	0,300	✓			
Ø0.430	+/-0.010	0,431	✓			
0.100	+/-0.010	0,100	✓			
0.125	+/-0.010	0,127	✓			
2.620	+/-0.010	2,622	✓			
3.500	+/-0.010	3,500	✓			
1.005	+/-0.010	1,005	✓			
Ø0.484	+0.005/-0.001	0,485	✓			
1.180	+/-0.010	1,180	✓			
3.150	+/-0.010	3,144	✓			
3.070	+/-0.010	3,063	✓			
R0.063	+/-0.010	R0,063	✓			

DART AEROSPACE LTD	Work Order: 173381 7L
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2	Part Number: D3488-1
Inspection Dwg: D3488 / DSK101 Rev: B / D	Page 2 of 2

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	Ø.508	/		vern	mm L-05
0.750	+/-0.010	.750	/		↓	
1.500	+/-0.010	1.500	/		↓	
11.18	+/-0.030	11.18	/		Height G	31006
R0.062	+/-0.010	.062	/		R6	
0.125	+/-0.010	0.122	/		vern	mm L-01
0.590	+/-0.010	0.583	/		↓	
0.793	+/-0.010	.793	/		↓	
1.351	+/-0.010	1.351	/		height	31006
1.317	+/-0.010	1.308	/		micro	mm L-01
1.802	+/-0.010	1.802	/		Height G	31006

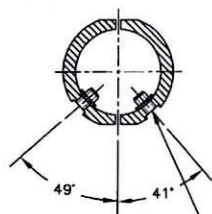
Measured by: [Signature]	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11/05/09 15/05/09	Date: 18/05/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-041	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM	[Signature]

SHOP COPY

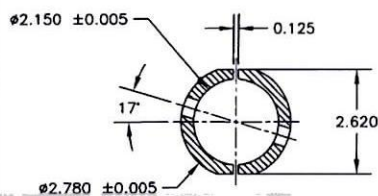
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WORK ORDER

NO. 173381 7L
20180301



SECTION B-B

Ø0.297
C'BORE Ø0.430 x 0.100
INSTALL ALS4-1032-225 (OR AKS4-1032-225)
OR ALS7-1032-225 OR AKS7-1032-225)
INSERTS AFTER FINISH
(4 PLACES)



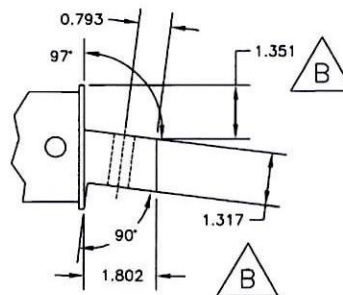
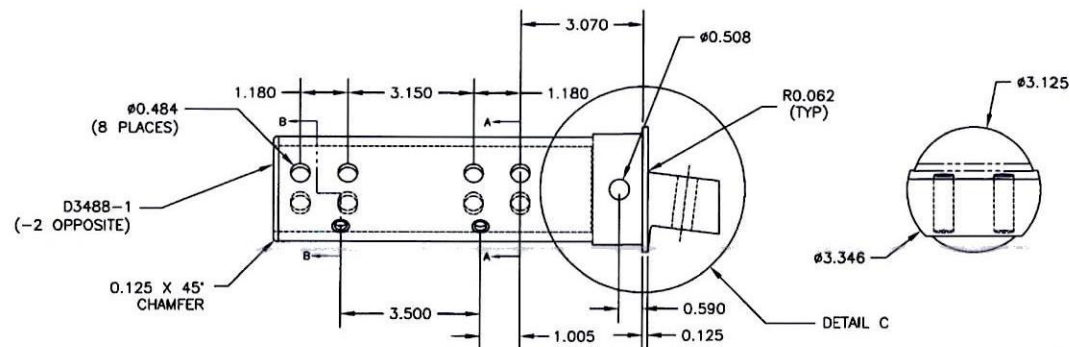
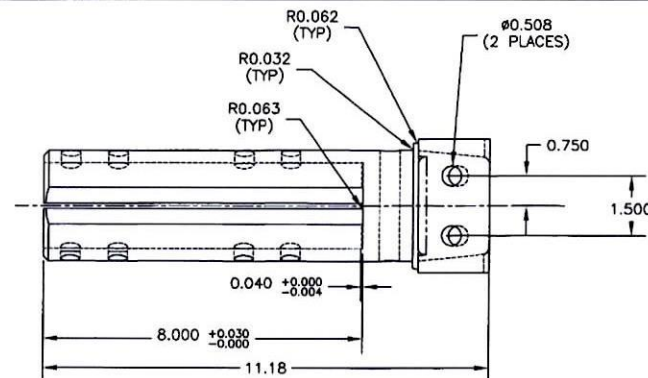
SECTION A-A

D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D3488-041	BLADE FITTING ASSEMBLY (LH)
		D3488-042	BLADE FITTING ASSEMBLY (RH)
1	1	D3488-1	BLADE FITTING (LH)
		D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING

- MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR
PER QQ-A-225/9
(REF. DART MATERIAL SPEC M7075T73R)
- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- INSTALL INSERTS AFTER POWDER COAT
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DETAIL C

D3488-041 SHOWN (D3488-042 OPPOSITE)

RELEASED
06.03.15 PH
REV. 05
EIN #734

B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	06.03.15	TITLE
		BLADE FITTING

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DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

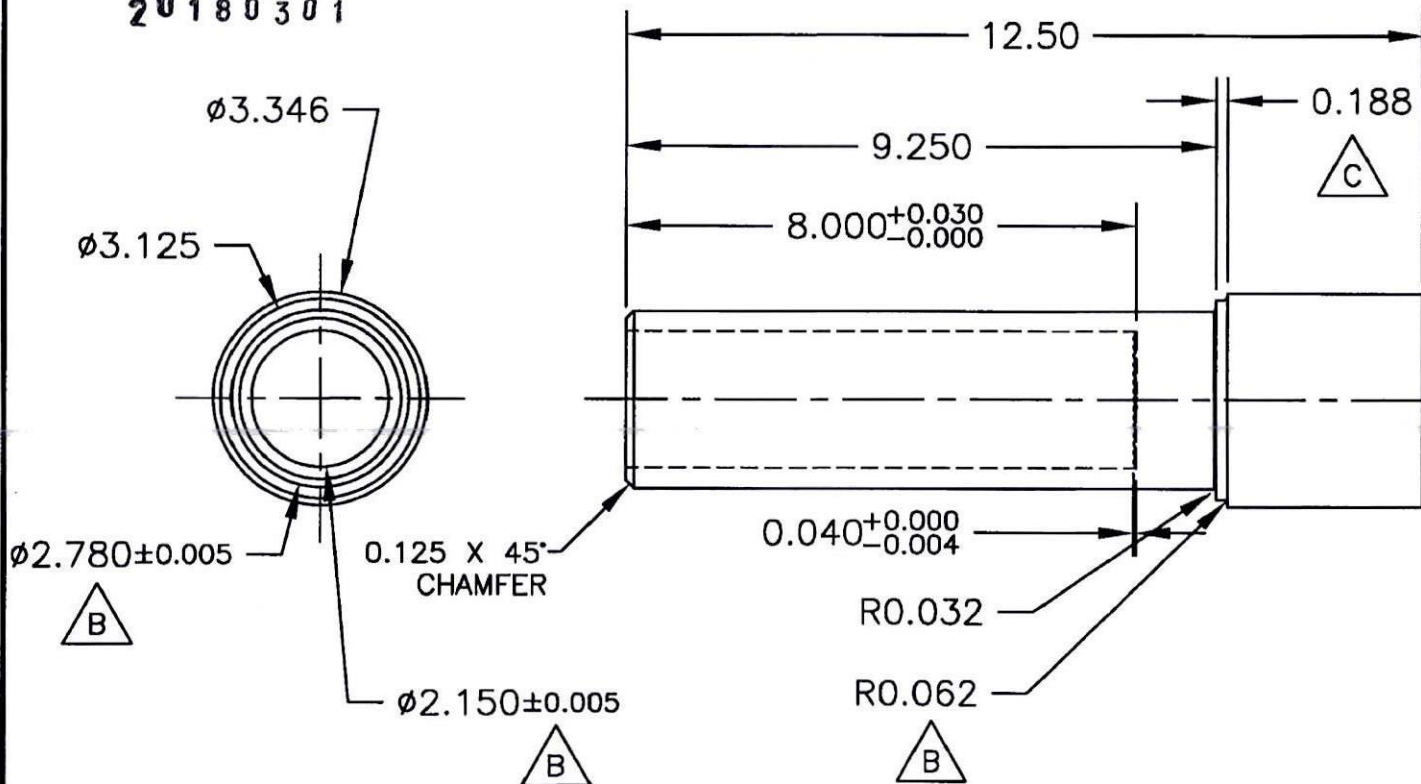
DRAWING NO. D3488
REV. B
SHEET 1 OF 1
SCALE 1:3

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. D
04	04	PORT HADLOCK, VA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
04	04	DSK 101	
DATE	TITLE	SCALE	
06.05.09	D3488-1/-2 TURNING DETAIL	1:3	
A	05.12.21	NEW ISSUE	
B	06.03.02	ADD TOLERANCES AND RADIUS	
C	06.04.17	0.188 WAS 0.125	
D	06.05.09	REMOVE DIAMETER FOR CHAMFER	

06-05-09

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20180301



DSK 101

- 1) MATERIAL: MAKE FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
- 2) FINISH: NONE
- 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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Container No: S070841



Part: D3488-041

Job No: 173381

Serial No/Batch: S070841

Revision:

Inspector:

Date: 05/12/18